

Work Order ID 63300

Wednesday, October 27, 2010 10:50:51 AM

Page 1

Item ID: D212-725-1-065F

Accept

Setup Start

Revision ID:

Stop

Item Name: Stiffener

Start Date: 10/27/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

10-10-28

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	S 10/10/08			(x4)			
130  Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00	SB 10/10/08			(4)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 10/10/09			(x4) -065			

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Page 3

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Required Date: 11/30/2010 Req'd Qty: 4.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	φ		
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4			
170  Packaging Packaging	Identify as per dwg & Stock Location: 389 Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Page 4

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/29

U 10-10-29

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, October 27, 2010 10:50:56 AM

Page 1

Work Order ID: 63300



Parent Item: D212-725-1-065F



Parent Item Name: Stiffener

Start Date: 10/27/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

103.8847

0.0617

0.259789



IB 10-10-09

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT22

103.8847

111381

11.89

113189

0.3947

114968

91.6

114968

4

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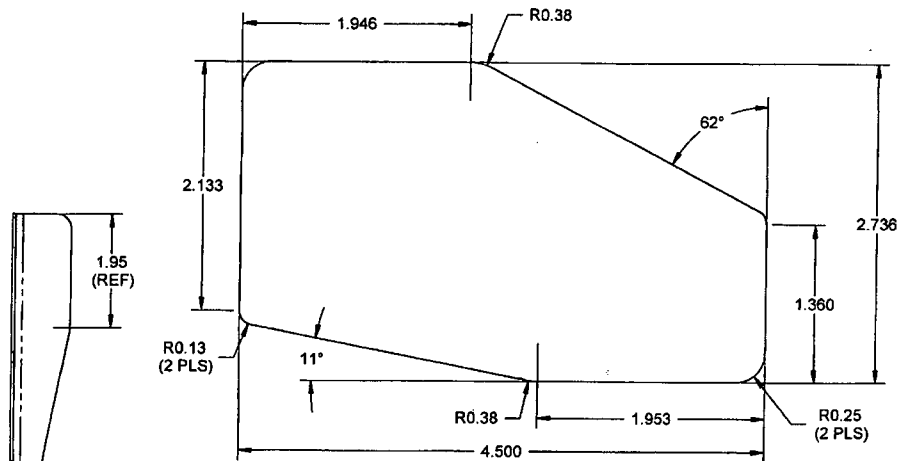
NOTE: Date & initial all entries

① 212-725-1-065 F

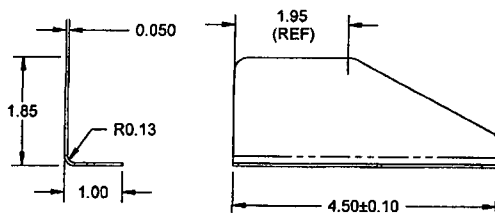
☒ First Article ☒ Prototype

Measured by: <u>18</u>	Audited by: <u>S</u>	Prototype Approval:
Date: <u>10-10-28</u>	Date: <u>10/10/25</u>	Date:

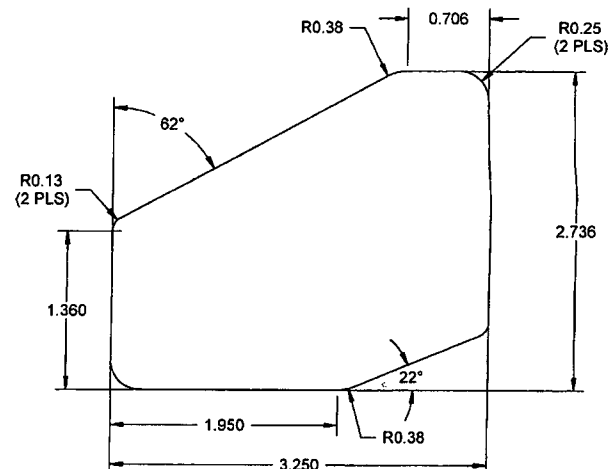
H:\FORMS\Quality Assurance\approved QA\FAI revD



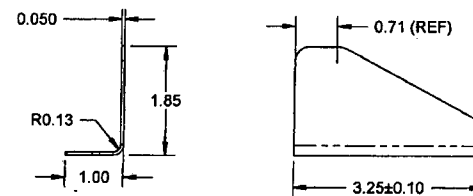
D212-725-1-063F FLAT PATTERN



**D212-725-1-063 STIFFENER, LH SHOWN
D212-725-1-064 STIFFENER, RH OPPOSITE
(MAKE FROM D212-725-1-063F FLAT PATTERN)
SCALE 1:2**



D212-725-1-065F FLAT PATTERN



**D212-725-1-065 STIFFENER, LH SHOWN
D212-725-1-066 STIFFENER, RH OPPOSITE
(MAKE FROM D212-725-1-065F FLAT PATTERN)
SCALE 1:2**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43300
BS10-10-27

RELEASED
2009-10-28

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED [Signature]	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 26 OF 44 SCALE 1:1
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